

Date: Thursday, 23/10/2008 10:53:41 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : LITTER TIE DOWN ASS'Y

Job Number : 42882

Estimate Number : 10360

P.O. Number :

Part Number : D2350

This Issue : 23/10/2008 S.O. No. :

Drawing Number : D2350 / D2363

Prsht Rev. : NC

Project Number : N/A

First Issue : // Type : MACHINED PARTS

Drawing Revision : B / F

Previous Run : 41337

Material :

Due Date : 15/11/2008

Qty: 8 Um: Each


Written By :

Checked & Approved By : JUD 08.9.23

Comment : est rev B 06.05.17 added ass'y EC

Est Rev:C 08-05-13 chg to revF DD verified by:EC

## Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 D6201 "T" Extrusion

Comment: Qty.: 1.0631 f(s)/Unit Total : ~~6.3788 f(s)~~ 5.3155

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion

Batch: H.A 08/10/25 (5)36793

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 12.150" long

H.A 08/10/25 (5)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2363 and Dwg D2363

H.A 08/10/26 (5)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 08/10/26 (5)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

M/08/10/27 (B)

6.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Tumble &amp; deburr

N/A. JUD 08.10.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A  
10-10-27

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H 08/10/07

(5X)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

7:45

OVEN TEMPERATURE:

320°

FINISH TIME:

8:15

FZ 08/10/28

(5)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-28

(X5)

11.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372

Fastener

41426

12.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444

Pip Pin

41429

13.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L

Washer

100793

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Job Number:



Seq. #: Machine Or Operation: Description :

14.0 MS21042L3 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) 109031

*Handwritten signature*

15.0 MS27039113 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw M105211

*Handwritten signature* 08/10/28 (5)

16.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

*Handwritten signature* 08/10/29 (5)

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten signature* 08/10/29 (45)

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 185

*Handwritten signature* 8/10/29

19.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten signature* 08/10/30

Job Completion



*Handwritten signature* 08/10/29

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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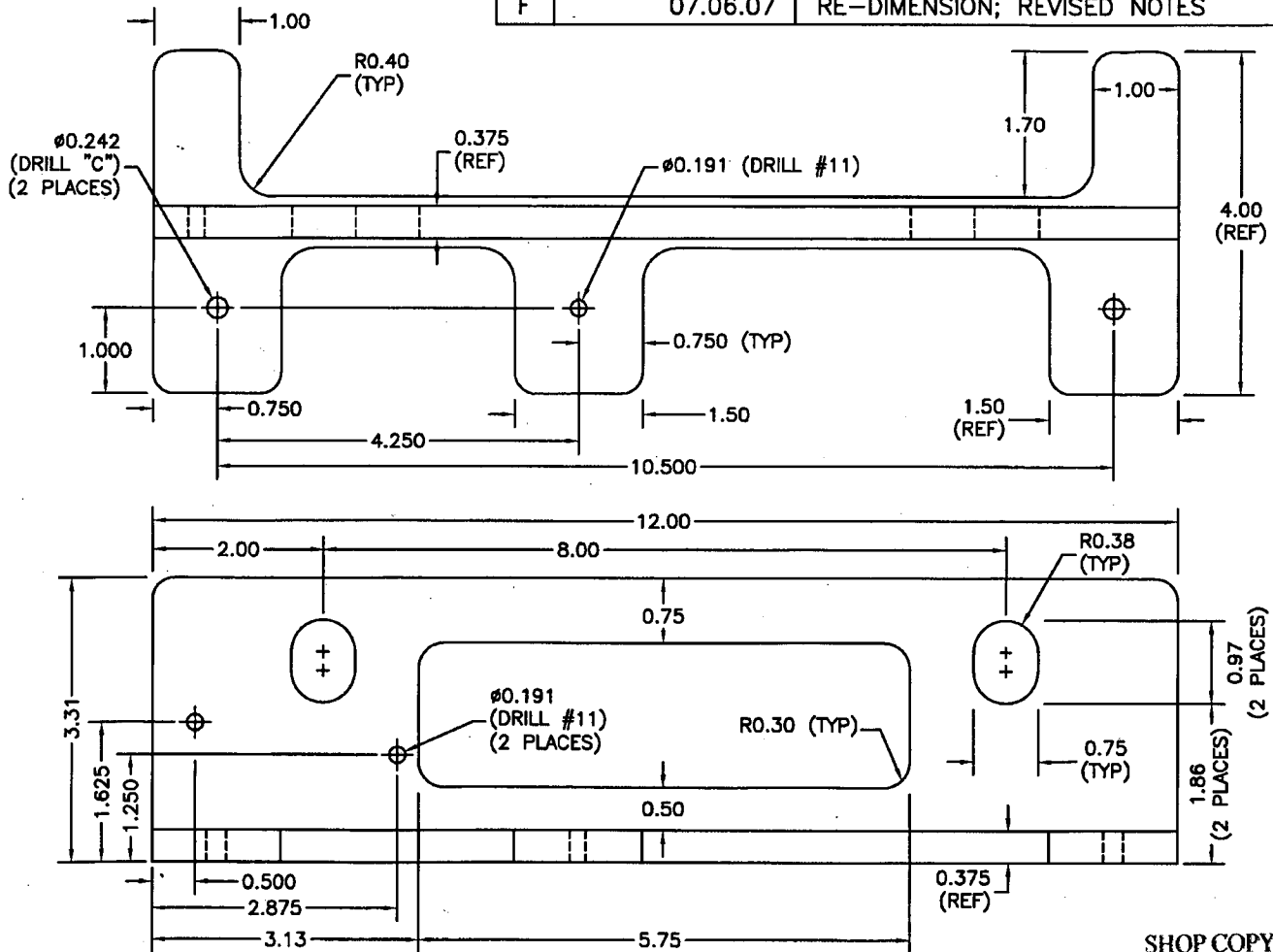
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**DART**

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D2363	REV. F SHEET 1 OF 1
DATE 07.06.07	TITLE LITTER TIE DOWN BRACKET	SCALE 1:2	
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	RE-DIMENSION; REVISED NOTES	

**RELEASED**

07.06.22

**D2363 LITTER TIE DOWN BRACKET**

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.3 SUBJECT TO AMENDMENT WITHOUT NOTICE  
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2363" USING FINE POINT PERMANENT INK MARKER

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WORK ORDER  
42882

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**Dart Aerospace Ltd**

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DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY SCALE	

RELEASED  
960607

D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<del>X</del> 3	AD960JD10 L	WASHER
1	MS21042LB	NUT
1	MS27039-A-13	SCREW

KE 99.04.29

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WORK ORDER  
NO. 42882

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

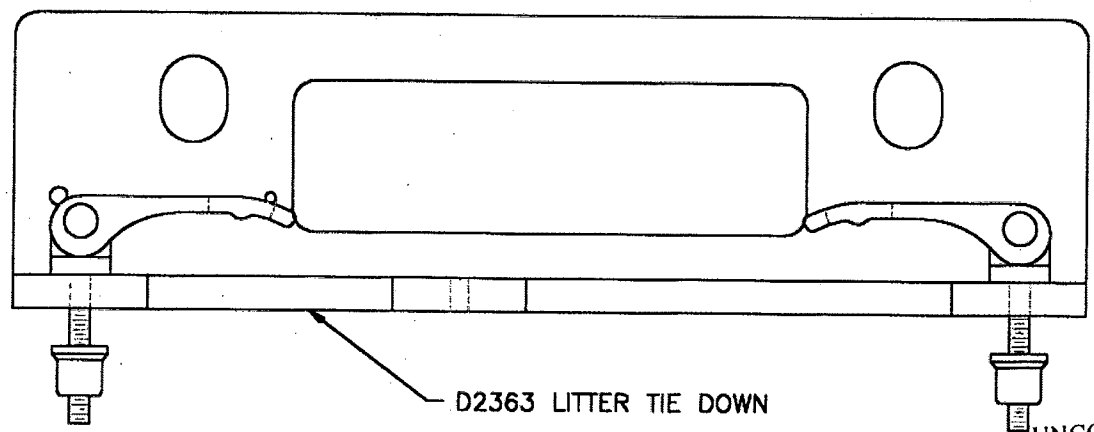
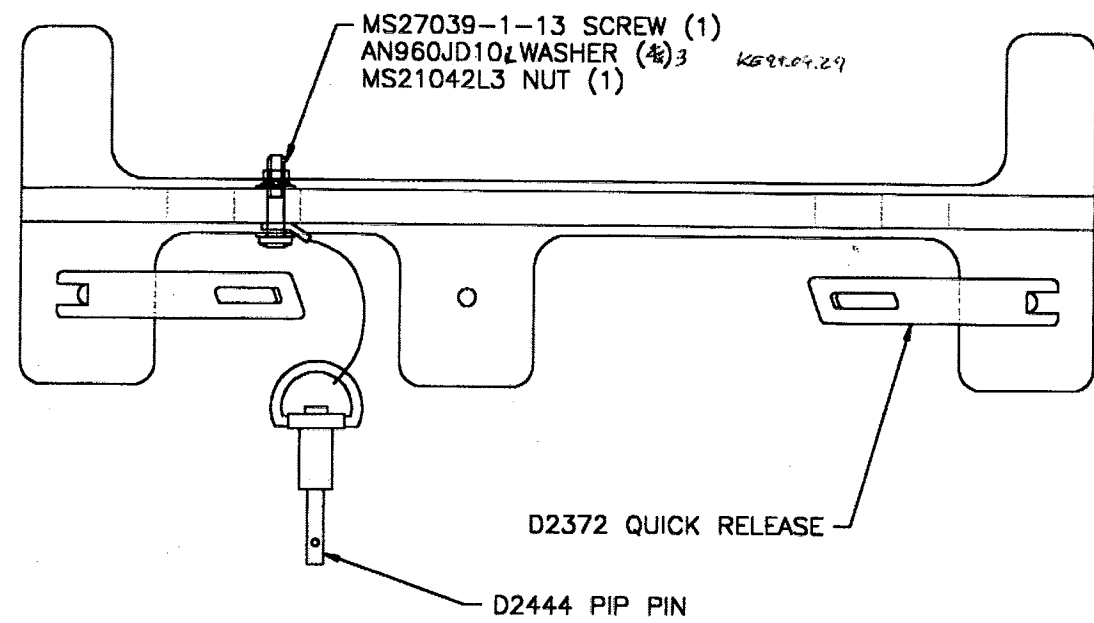
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DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. 8
CHECKED	APPROVED	D2350	SHEET 2 OF 2
DATE		TITLE	SCALE
95:02:20		LITTER TIE DOWN ASSEMBLY	

RELEASED  
960607



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WORK ORDER  
NO. 242852

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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